Work Order ID 92106

Tuesday, October 23, 2012 4:08:37 PM

92106

Item ID: PB67-43001-57
Revision ID:
Item Name: Stabilizer Arm

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 10/23/2012 **Start Qty:** 4.00 *4*
Required Date: 11/2/2012 **Req'd Qty:** 4.00 *4*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 12-10-25 **Tooling:** ______ **Date:** ______
QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
B67-43001 -57	~~C~~ 4

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100* Large Fab / Large Fab	Weld per dwg A/R Aluminum rod Batch: 122358 Large Fab	0.00				4	Ø		[initials] 12·11·21
	Memo 1-Weld assembly as per dwg PB67-43001	0.00							
110 *110* QC / Quality Control	QC5- Inspect part completeness to step on W/O	0.00				(4)	12-11-21		DAS 09 9-89
	Memo	0.00							
120 *120* QC / Quality Control	QC9- Inspect visual per QSI004- Fusion Welds	0.00				(4)	12-11-21		DAS 09 9-89
	Memo	0.00							

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 92106

Tuesday, October 23, 2012 4:08:37 PM

92106

Item ID:	PB67-43001-57	**Accept**	*N900040100*
Revision ID:		**Setup Start**	*NS1*
Item Name:	Stabilizer Arm	**Stop**	*NS2*
Start Date:	10/23/2012	**Start Qty:** 4.00 *4*	**Cust Item ID:**
Required Date:	11/2/2012	**Req'd Qty:** 4.00 *4*	**Customer:**
Reference:			

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______ **Run Start** *NR1*

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	Small Fab **Memo** 1- line drill -107 and -109 using existing pilot hole of -107 as per dwg 2- install spring pin	0.00 0.00				4	∅		Ae 12/11/21
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00 DAS 15 89 12-11-26				4			Pto next page →
150 *150* Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 **Memo** START TIME: 3:30 OVEN TEMPERATURE: 320°F FINISH TIME: 4:00	0.00 0.00				4X	∅		M 12/11/27

M18144

DQA: ________ Date: ______________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________ Part No. ____________ NCR No. ____________	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐ Equip/Tooling ☐ Operator ☒ Material ☐ Setup ☐ Other ☐ Process ☐ Supplier ☐ Training ☐ Unapproved ☐	12·11·22	130	3 out of 4	part drilled in revers order		No action taken not a problem were pin is located pin is still locked in place of the male eye			

FAULT CATEGORY

Landing Gear
- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General
- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other ____________

NCR: (Yes) / No

DQA: [signature] Date: 12/12/04

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: [signature] Date: [signature]

Work Order: 92106
Part No. PB67-43001-57
NCR No. 12-2090

DISPOSITION

- [ ] Rework
- [ ] Scrap
- [X] Use-as-is
- [ ] Work Order Update

AGAINST DEPARTMENT/PROCESS

- [ ] Skid-tube
- [ ] Machining
- [ ] Thermoforming
- [X] Large Fab
- [ ] Crosstube
- [ ] Small Fab
- [ ] Finishing
- [ ] Composite
- [ ] Water Jet
- [ ] Prod. Eng. Coor.
- [ ] Rec/Store/Packaging
- [ ] Supplier
- [ ] Engineering
- [ ] Quality
- [ ] Other

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
[ ] Doc/Data [ ] Equip/Tooling [X] Operator [ ] Material [ ] Setup [ ] Other [ ] Process [ ] Supplier [ ] Training [ ] Unapproved	12/4/23	180.	13	Operator Drill hole in wrong orientation for MS171534 spring slotted tension pin in the B67-4300-109. R.C. Lack of Attention to Drawing	DAS 16 9-86 AS2042 12/4/23	Part has no effect on finished Product. Acceptable as is. X3 Parts Affects.	[signature] 12/11/26	DAS 15 9-89 12 11 26	DAS 16 9-86 AS2042 12/4/23

FAULT CATEGORY

Landing Gear

- [ ] Bending
- [ ] Centre Not Concentric to O/S
- [ ] Cracks
- [ ] Crushed/Crimped
- [ ] Cuffs
- [ ] Heat Treat
- [ ] Inspection Strip in Tube
- [ ] Ripples in Bend
- [ ] Torque Waves in Extrusion
- [ ] Turning Sequence
- [ ] Wave/Twist in Tube

General

- [ ] Bend
- [ ] BOM/Route
- [ ] Broken/Damaged
- [ ] Burrs
- [ ] Contamination
- [ ] Countersink
- [ ] Cut Too Short
- [ ] Drill Holes
- [ ] Drawing
- [ ] Finish
- [ ] Folio
- [ ] Grain
- [ ] Hardware
- [ ] Inspection Incomplete
- [ ] Instructions Incomplete/Unclear
- [ ] Maintenance
- [ ] Mislabeled
- [ ] Misread
- [ ] Offset
- [ ] Out of Calibration
- [ ] Out of Sequence
- [ ] Outside Dimensions
- [ ] Ovalized
- [ ] Over/Under tolerance
- [ ] Part Incorrect
- [ ] Part Lost/Missing
- [ ] Part Moved
- [ ] Positioned Wrong
- [ ] Power Loss/Surge
- [ ] Pressure/Forced
- [ ] Temperature/Cure
- [ ] Weld
- [ ] Wrong Stock Pulled
- [X] Other

Failure to Read Drawing correctly. Lack of Attention.

Work Order ID 92106

Tuesday, October 23, 2012 4:08:37 PM

92106

Item ID: PB67-43001-57 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Stabilizer Arm **Stop** *NS2*

Start Date: 10/23/2012 **Start Qty:** 4.00 *4* **Cust Item ID:**

Required Date: 11/2/2012 **Req'd Qty:** 4.00 *4* **Customer:**

Reference:

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________ **Run Start** *NR1*

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish	0.00				4	0	12-11-28	[stamp]
	Memo	0.00							
170 *170* Packaging Packaging	Identify as per dwg & Stock Location ST 209 A	0.00				4x			SP 12-11-27
	Memo	0.00							
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00						12/11/28	[signature]
	Memo	0.00							

MF 12-11-28

DQA: ________ Date: ______________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________	DISPOSITION	AGAINST DEPARTMENT/PROCESS
Part No. ____________	Rework ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
	Use-as-is ☐	Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
	Work Order Update ☐	Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ____________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

Tuesday, October 23, 2012 4:08:37 PM

Work Order ID: 92106

Parent Item: PB67-43001-57

Parent Item Name: Stabilizer Arm

Start Date: 10/23/2012 **Required Date:** 11/2/2012

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP Rev:A 08-07-25 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-107 Tube Arm		Manufactured	No			100	Each	1.0000	1	4	B90892 → (4) Ae	12/11/21	
PB67-43001-111 Tube End Plate		Manufactured	No			100	Each	2.0000	1	4	B90894 - Ae (+2)	12/11/21	
240-107 SPRING SLOTTED PIN		Purchased	No			130	Each	159.0000	2	8	Ae	12/11/21	
PB67-43001-109 Male Eye		Manufactured	No			130	Each	0.0000	1	4	B90893 → (4) Ae	12/11/21	

PB67-43001-107 locations:

Location		Loc Qty	Loc Code	
ST209a		1		
	62130	1		

PB67-43001-111 locations:

Location		Loc Qty	Loc Code	
ST445		2		
	41476	2		(4) 2

240-107 locations:

Location		Loc Qty	Loc Code	
122089		81		
	122089	81		(8)
ST400		78		
	115827	78		

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________________

Part No. ____________________

NCR No. ____________________

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

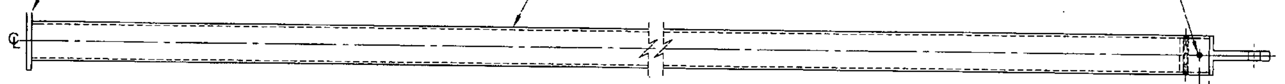
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

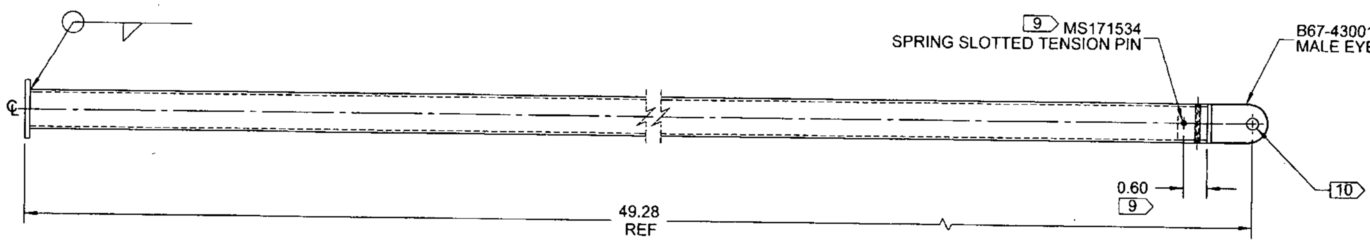
FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

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ENG
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SUBJECT
WITH
WO
NO _92106 MLJ
12-10-25

ITEM	QTY -57	P/N	DESCRIPTION
1	X	B67-43001-57	STABILIZER ARM
3	1	B67-43001-107	TUBE ARM
4	1	B67-43001-109	MALE EYE
5	1	B67-43001-111	TUBE END PLATE
7	2	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)





B67-43001-57 STABILIZER ARM

RELEASED
2009-09-24

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.00 lbs
8) WELDING: PER QSI 004
9) PRIOR TO POWDER COAT, ALIGN B67-43001-109 ON B67-43001-107 AS SHOWN AND DRILL QTY.(2) Ø0.129 HOLES THROUGH BOTH PARTS AND FASTEN B67-43001-109 TO B67-43001-107 USING QTY.(2) MS171534 SPRING SLOTTED PIN
10) MASK PRIOR TO POWDER COAT

REV.	DESCRIPTION	BY	DATE
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISONS, REFER TO SHEET 13 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.06.25

DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. B67-43001-57 — REV. C — SHEET 1 OF 1
MFG. APPR.		
APPROVED		TITLE STABILIZER ARM — SCALE NTS
DE APPR.	N/A	
DATE	09.06.25	